

Work Order ID 165158

Thursday, August 17, 2017 10:37:05 AM

165158

Page 1

Item ID: 647.0112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Bracket
 Start Date: 9/8/2017 Start Qty: 135.00 ***135*** Cust Item ID:
 Required Date: 9/29/2017 Req'd Qty: 135.00 ***135*** Customer:
 Reference:

Approvals: Process Plan: UM Date: 7/8/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.0100	A

100	FLOW WATER JET	0.02							
100									
Waterjet	Memo	3.89							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	1.35							
Quality Control									

17/9/29

135

02/17/08/18

135

02/17/08/18

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 2.70				<u>135</u>			DA6 38 9-89 AUG 21 2017
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo USE DT9834 FOR FORMING	0.00 3.36				<u>135</u>			ML6 17-8-22
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 2.70				<u>135</u>			DA6 38 9-89 AUG 24 2017

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Page 4

Item ID: 647.0112 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Strut Bracket
Start Date: 9/8/2017 Start Qty: 135.00 ***135*** Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	13.50							
Quality Control									

DAS
21
9-89

SEP 13 2017

Picklist Print

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Page 1

Work Order ID: 165158

165158

Parent Item: 647.0112

647 0112

Parent Item Name: Strut Bracket

Start Date: 9/8/2017

Required Date: 9/29/2017

Start Qty: 135.00

Required Qty: 135.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	47.1000	0.0325	4.618421			

M304S14GA

304SS sheet .080

02/17/08/18

Location

Loc Qty

Loc Code

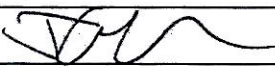
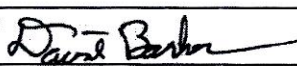
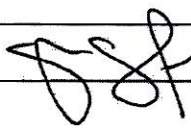
MAT020

47.1

m13776

47.1

4.6

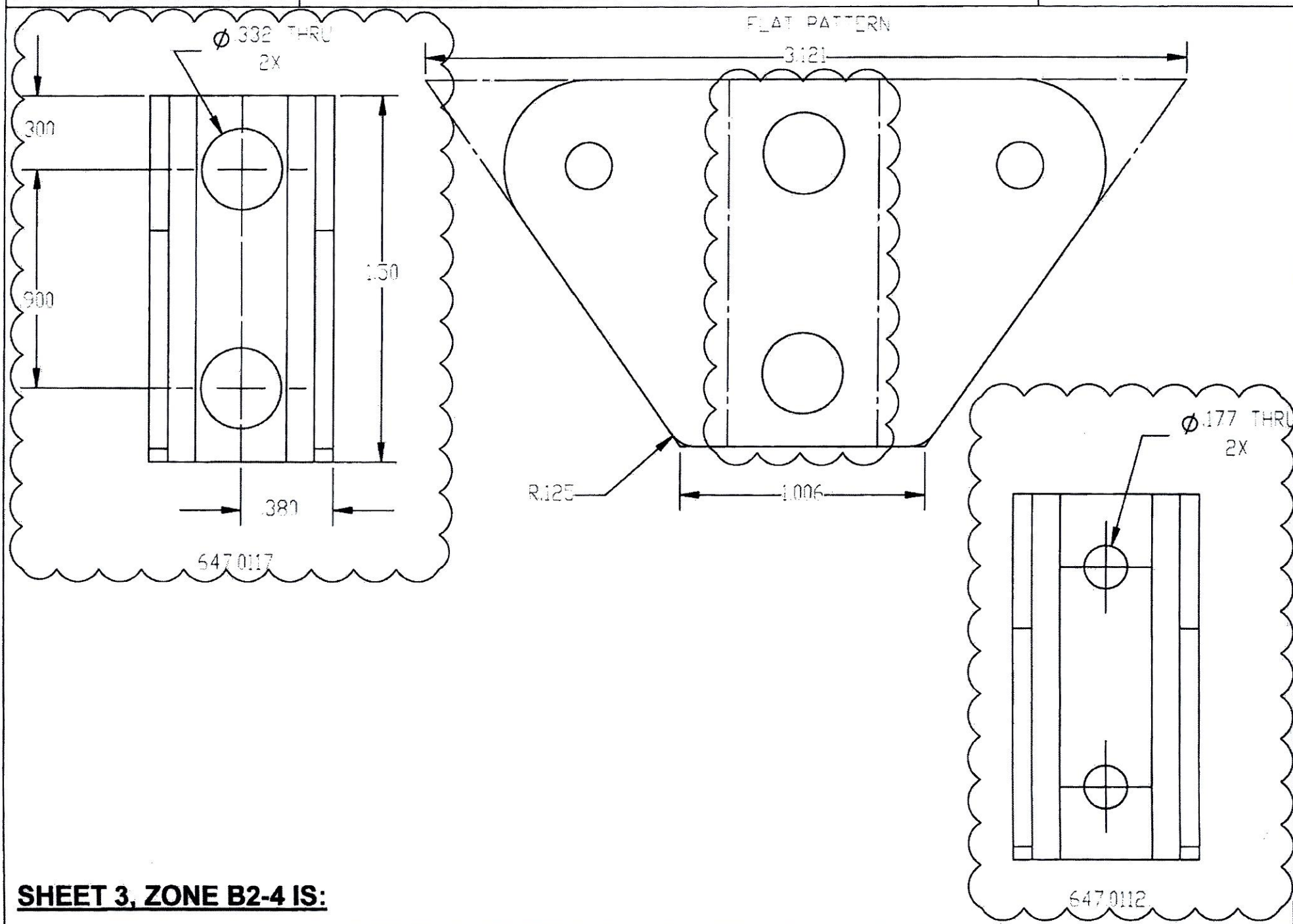
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: SHEET METAL				
	APPROVED BY: ENGR 	MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

- NOTES:
- IS** →
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
 - 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
 - 3. DEBURR AND BREAK ALL SHARP EDGES.
 - 4. IDENTIFY IAW MPP-120.
 - 5 MATERIAL: 304 SS IAW AMS 5643.
 - 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
 - 7 OTHER DIMENSIONS SAME AS 647.0112.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165158
WY 17/8/16

SHEET 1, ZONE D1 IS:

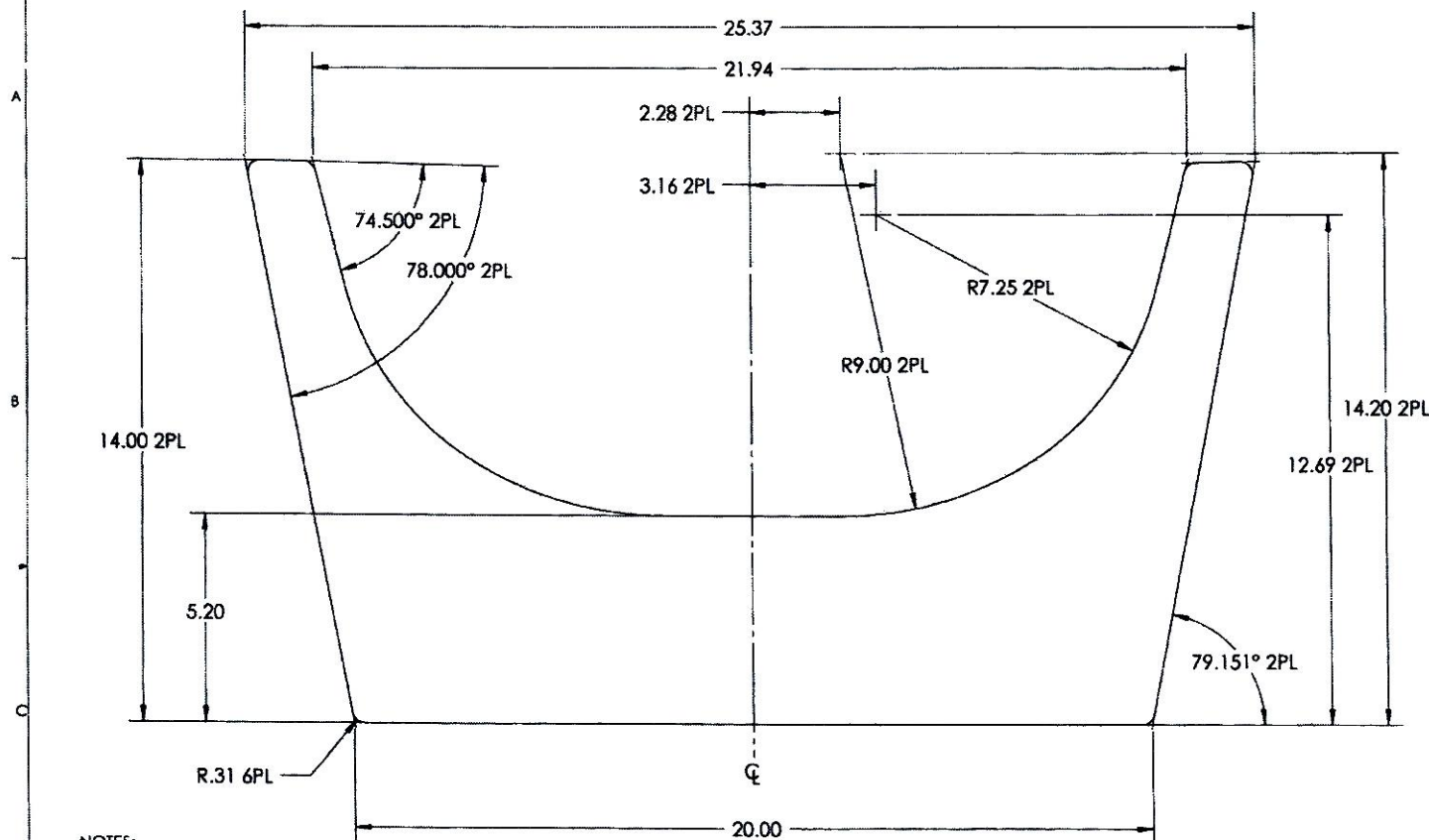
C	647.0117	STRUT BRACKET		△	△
F/N TC	PART NUMBER	DESCRIPTION		MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:		CHANGE CATEGORY		DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM		☐ MAJOR ☒ MINOR		☐ YES ☒ NO	



SHEET 3, ZONE B2-4 IS:

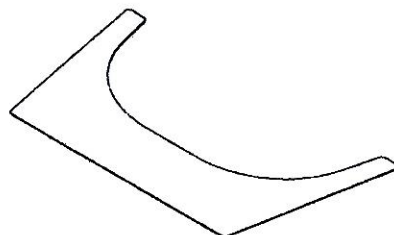
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
REV.	LAST PROTOTYPE REVISION P22		AUC
H.D.	INITIAL RELEASE	02/28/09	P. BRAVO
A.	INCORPORATED ECH 02722 02944 02945	04/26/11	P. BRAVO



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



647.0110

UNINCORPORATED ECN(s)

03985

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY		PARTS LIST			
NEXT ASSY (S)		APICAL INDUSTRIES			
646.9500		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)/24-5300			
		SHEETMETAL			
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°			
		REV	CAGE CODE	DWG	REV
		B	07/MX	647.0100	A
		SCALE NONE			SHEET 1 OF 6

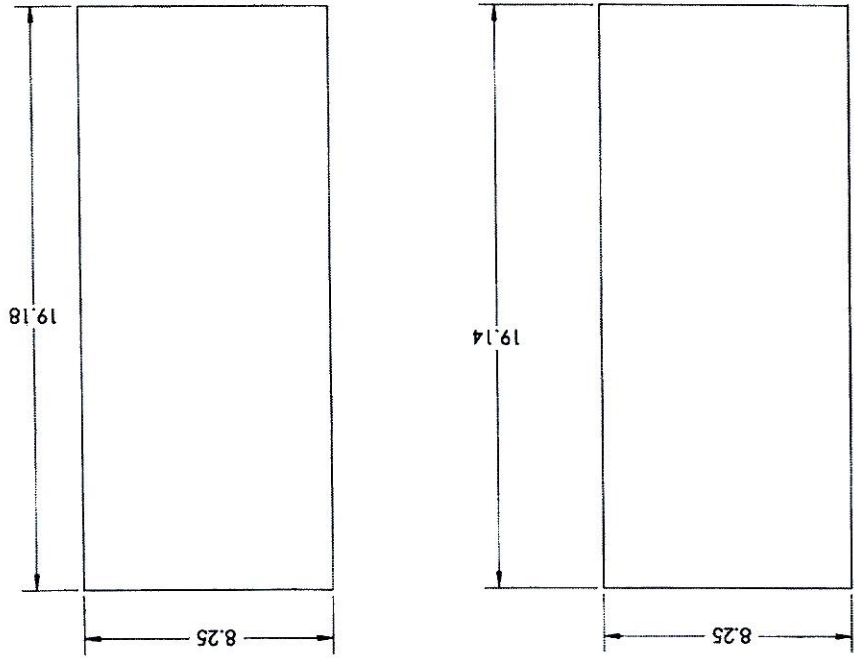
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

SHEETMETAL

647.0100

REV. A

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FLAT PATTERN

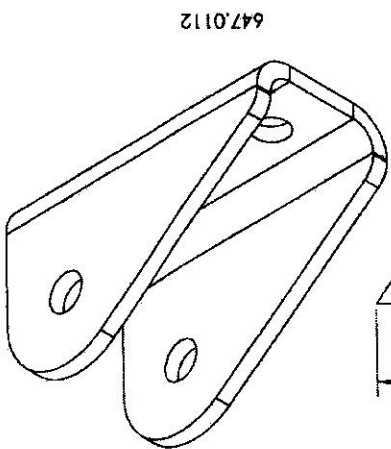
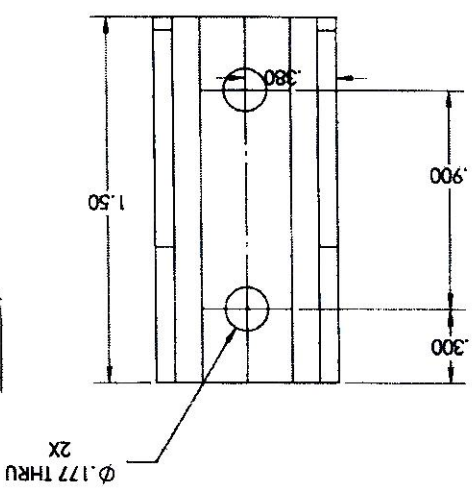
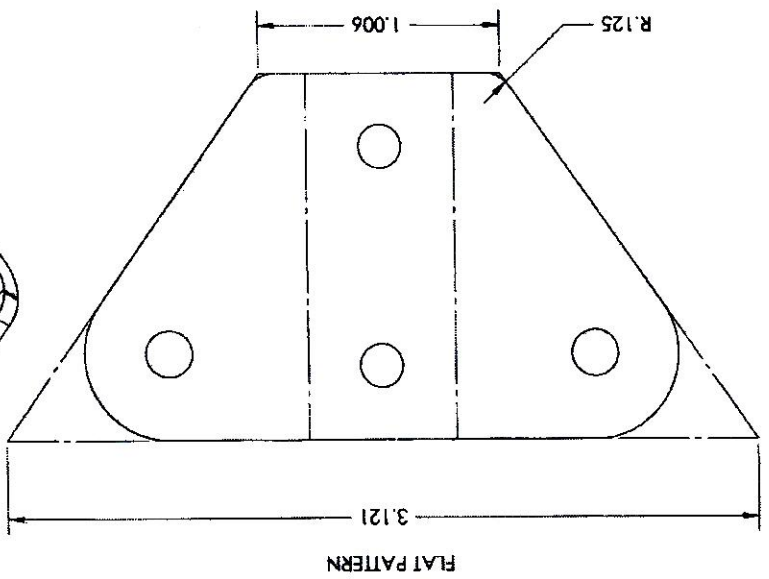
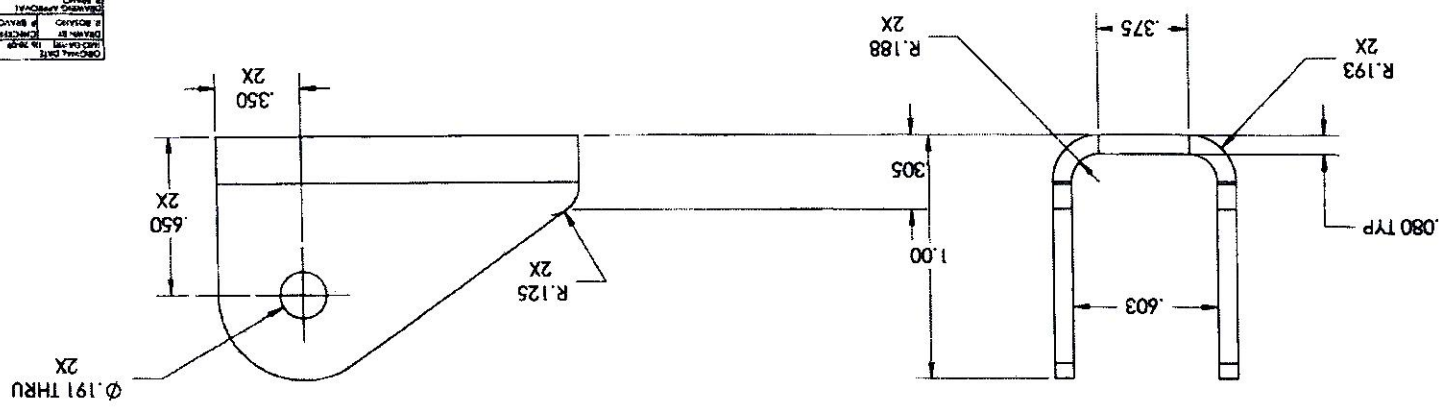
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R83.40

647.0111

2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92036-3512		SHEETMETAL 647.0100		SHEET 2 OF 6	
APICAL INDUSTRIES		2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92036-3512		SHEETMETAL 647.0100	

APICAL INDUSTRIES		SHEETMETAL	
2808 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		SHEET 3 OF 6	
REV	DATE	BY	DESCRIPTION
A			
647.0100		SHEETMETAL	
SCALE NONE		SHEET 3 OF 6	

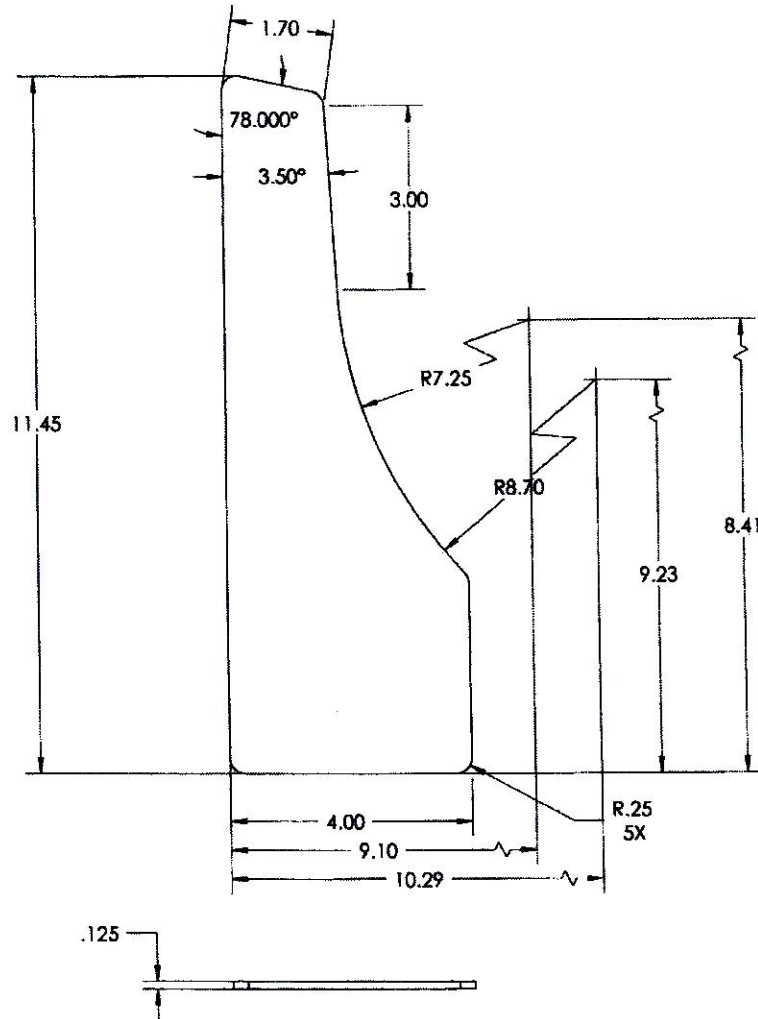


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REV	DATE	BY	DESCRIPTION

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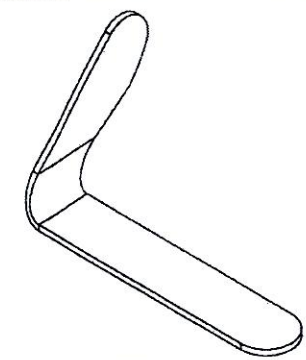
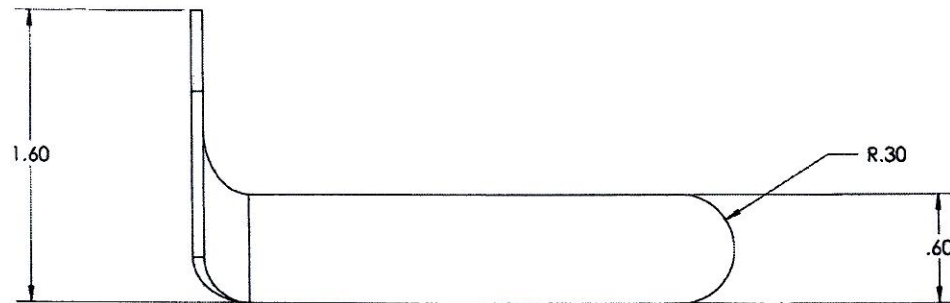
REV	DESCRIPTION	DATE	APPROVED



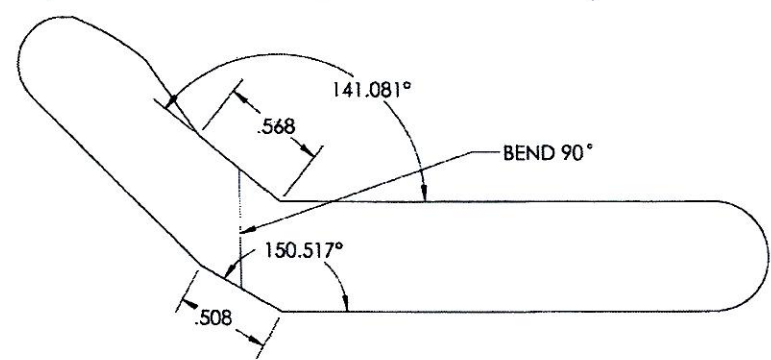
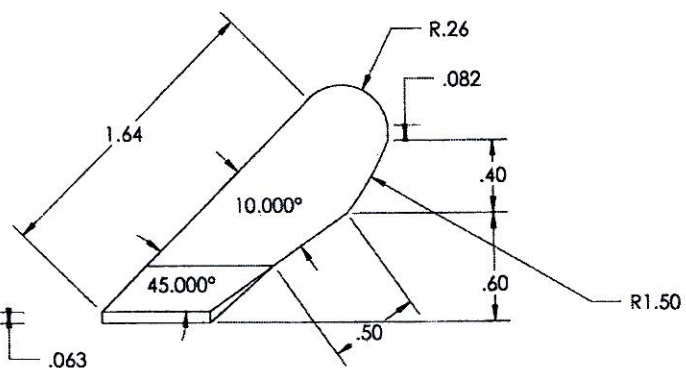
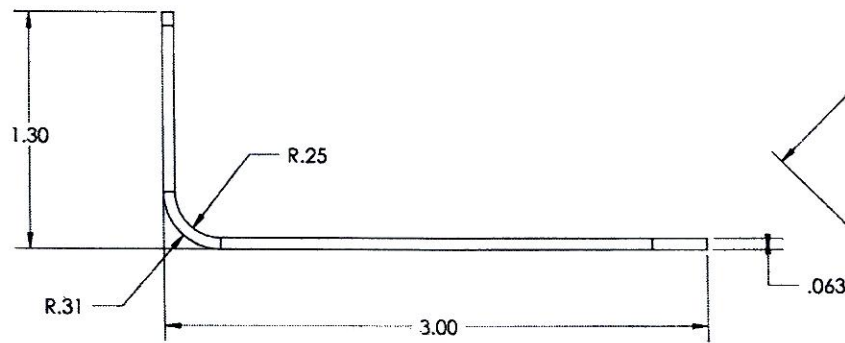
ORIGINAL DATE: 05-28-09		APICAL INDUSTRIES	
DRAWN BY: P. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAYO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: P. BRAYO		SHEETMETAL	
CONTRACT NO.		DWG. NO. 647.010J	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE: NONE	SHEET 4 OF 6

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

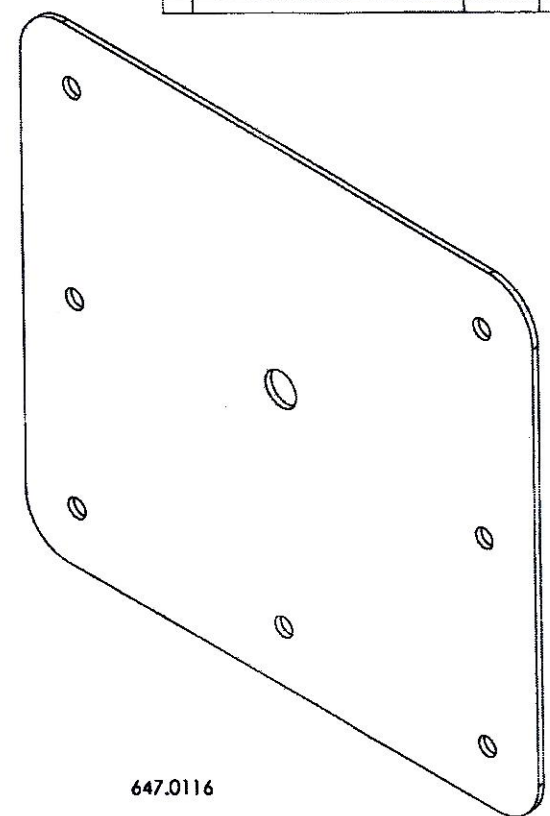
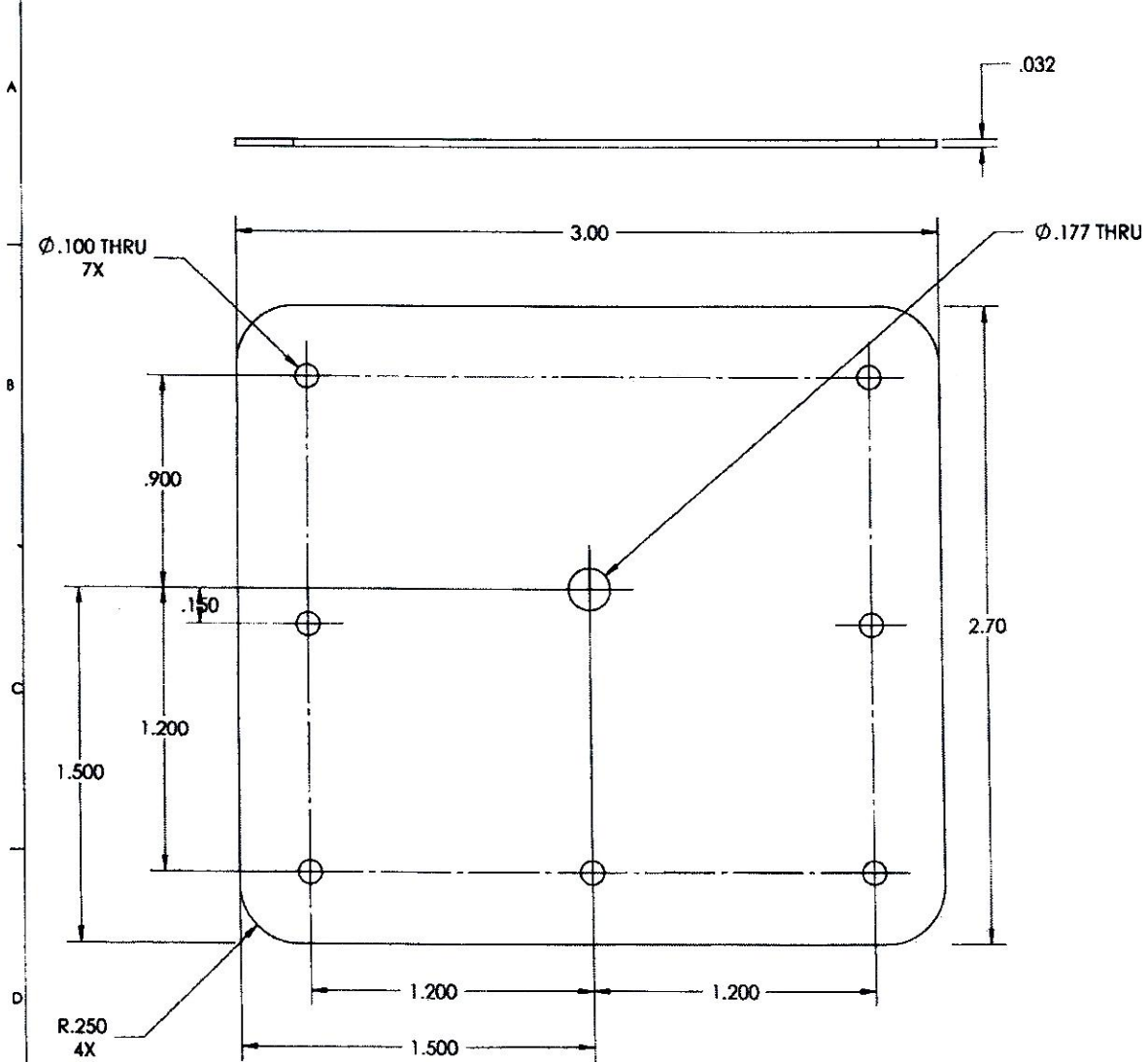


FLAT PATTERN

ORIGINAL DATE REVISIONS 05-28-09		APICAL INDUSTRIES	
DRAWN BY P. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY H. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. ROSANO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± 1°	
CONTRACT NO.		SIZE / CAGE CODE B / 07M26	DWG. NO. 647.0100
		SCALE: NONE	REV. A SHEET 5 OF 6

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE: 10-20-78 DRAWN BY: F. ROSANO CHECKED BY: P. BRAYCO DRAWING APPROVAL: P. BRAYCO DATE: 10-20-78 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SRV: 8 CAGE CODE: 07M26 SCALE: NONE	DWG. NO.: 647.0100 SHEET: 6 OF 6

